

Date: Monday, 4/24/2006 10:25:45 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG WELDMENT
Job Number : 26765	
Estimate Number : 11873	
P.O. Number : N/A	Part Number : D335315
This Issue : 4/24/2006 S.O. No. : N/A	Drawing Number : D3353 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <i>SAC COMMENT Below</i>	Due Date : 5/30/2006 Qty: 8 Um: Each
Checked & Approved By : <i>06.04.24</i>	
Comment : est rev. A 06.01.14 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010B0750X0200	1010-1025 BAR
-----	-----------------	---------------



Comment: Qty.: 0.2520 f(s)/Unit Total: 2.0160 f(s)

1010-1025 BAR

AISI 1010-1025 Steel bar 2.00" x 0.750"

Batch: M17270

J.F. 06/05/20 8

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks 2.870" long

J.F. 06/05/20 8

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA613 and Dwg D3353

2- Deburr

J.F. 06/05/21 8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/05/21 8

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 06.05.21 8

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *PD*   Date: 06/05/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 4/24/2006 10:25:45 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 26765

Part Number: D335315

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PPP/stuck 57428

106/5/23 (8)

Job Completion



Inspection Level 21  
C/06/05/24

26/05/24 (8)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

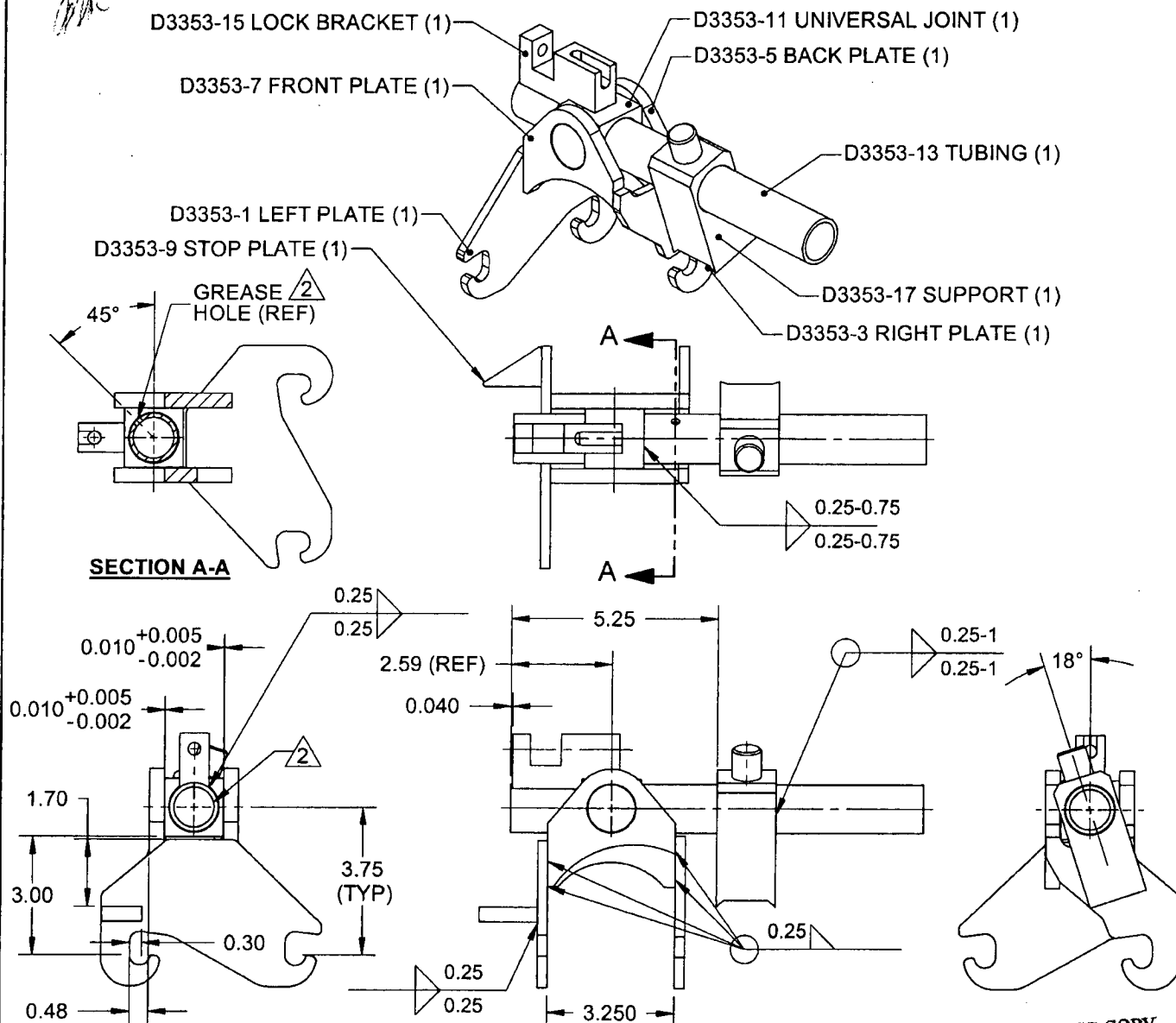
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

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CHECKED	APPROVED	DRAWING NO. <b>D3353</b>	REV. A SHEET 1 OF 10
DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:4
A	04.12.14	NEW ISSUE	

**RELEASED**  
06/5/10**SECTION A-A****D3353-041 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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NO. **26765**

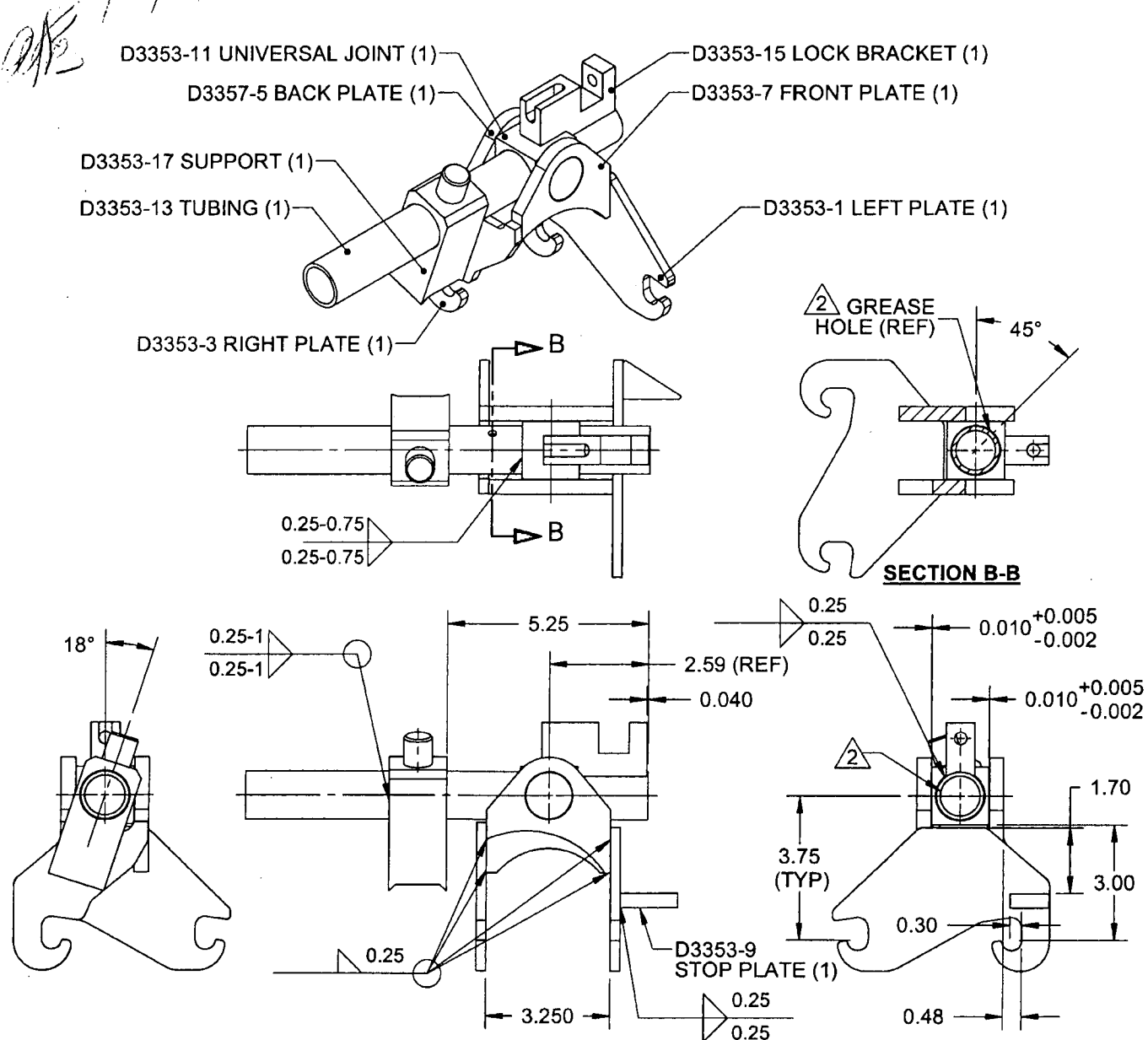
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:4

RELEASED  
06/03/59



### D3353-042 LUG WELDMENT

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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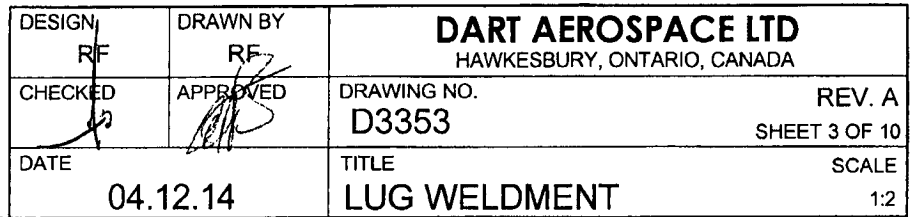
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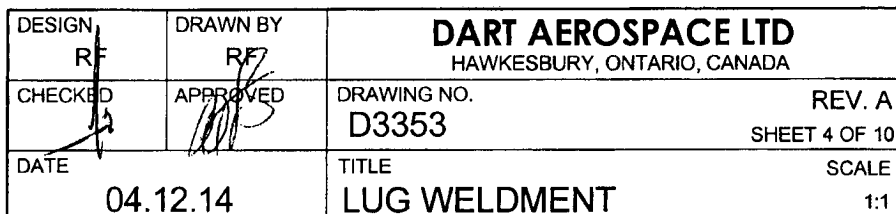
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APR 07 1964



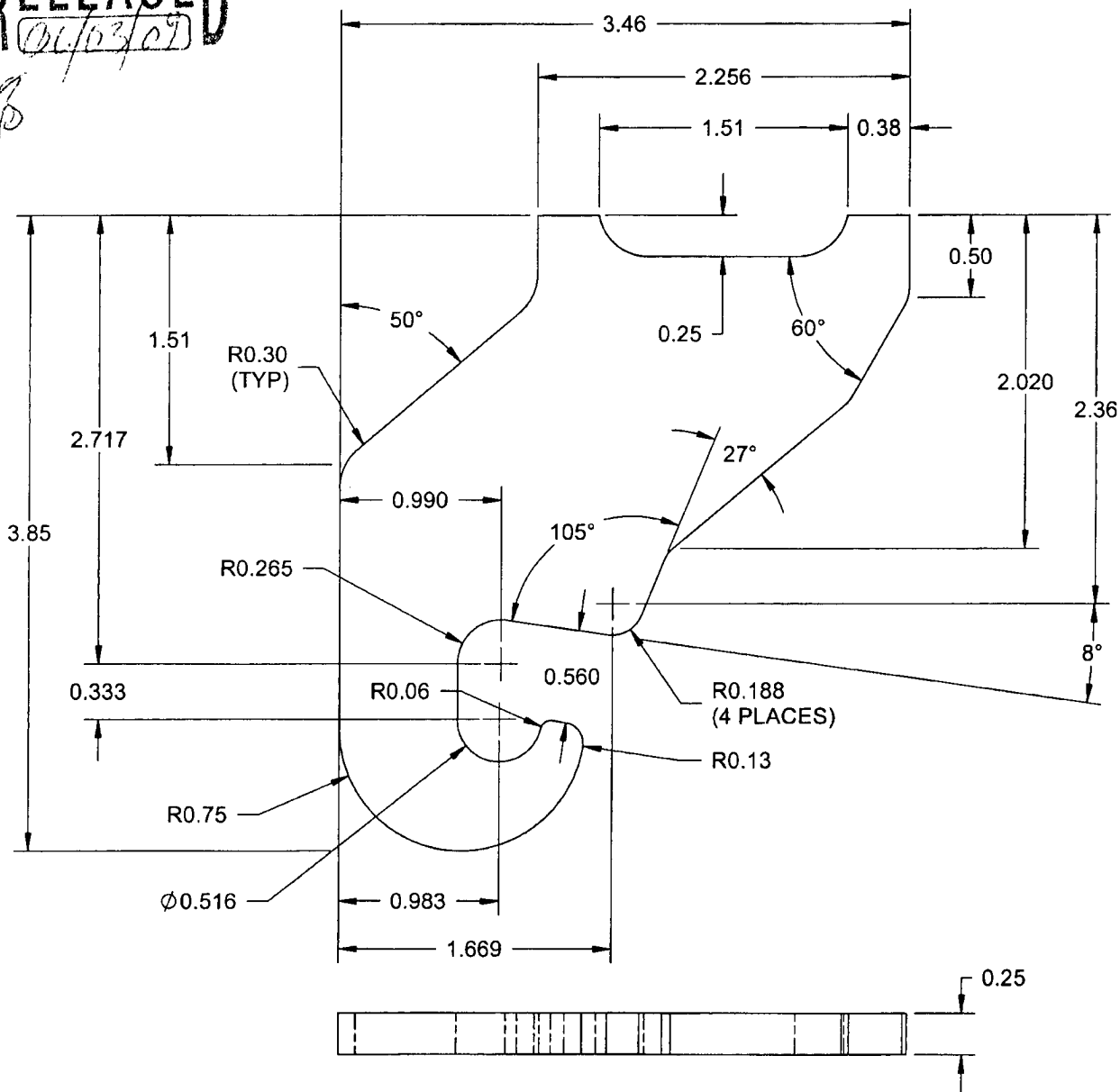
1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21  
38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)  
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

WORK ORDER  
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RELEASED  
06/03/09



### **D3353-3 RIGHT PLATE**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21,  
38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)  
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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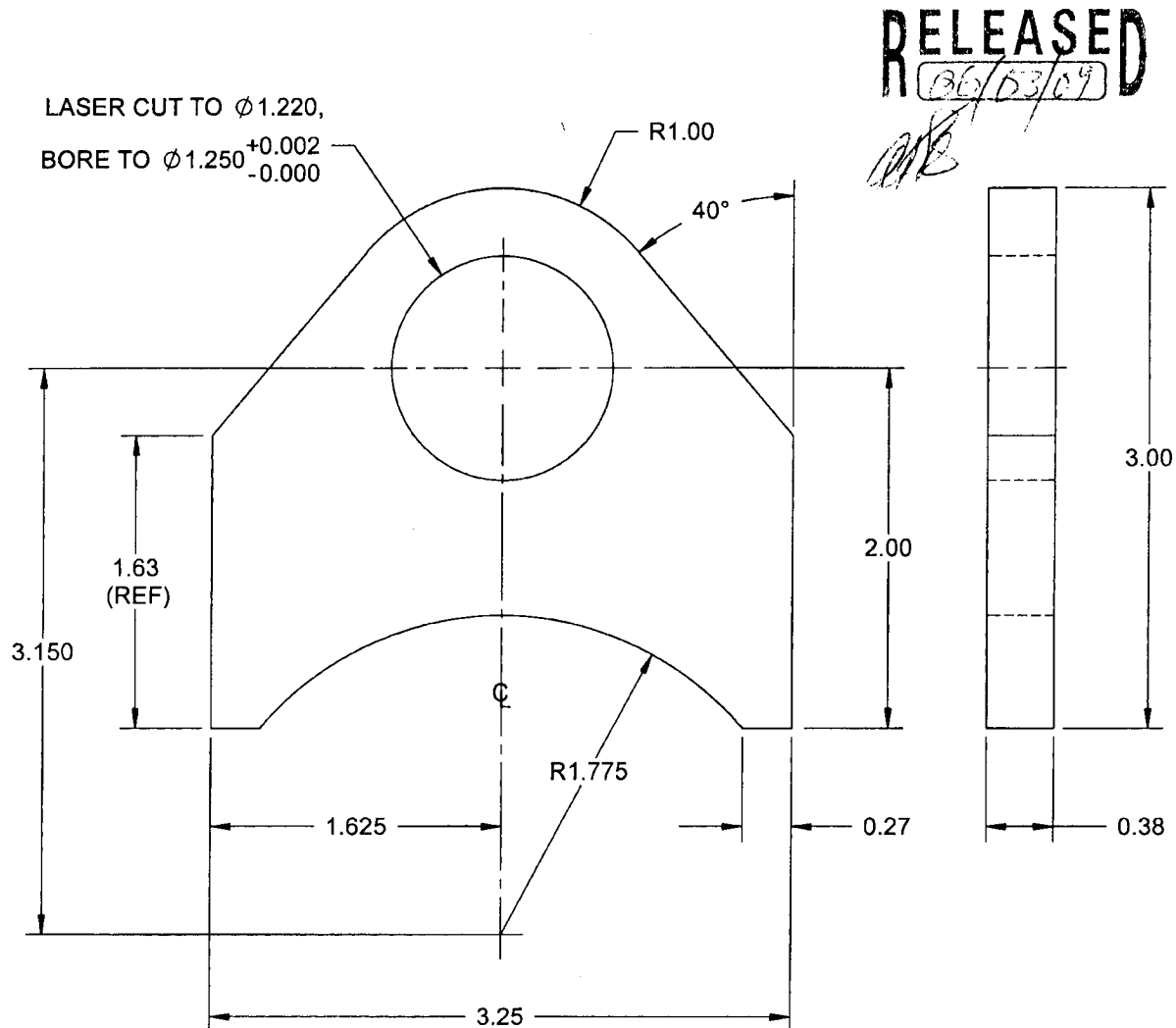
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DATE <b>04.12.14</b>		TITLE <b>LUG WELDMENT</b>	SHEET 5 OF 10
			SCALE 1:1

**D3353-5 BACK PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

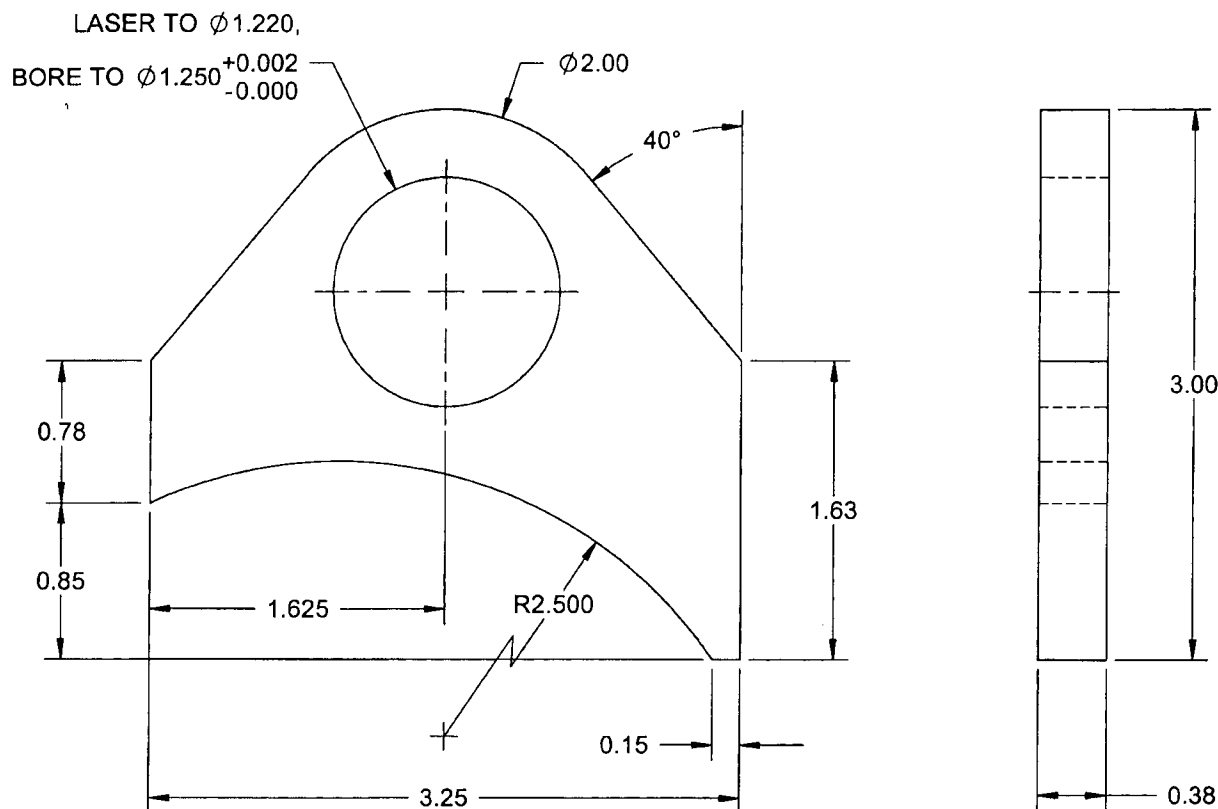
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DATE 04.12.14		TITLE LUG WELDMENT	SHEET 6 OF 10 SCALE 1:1

**RELEASED**  
*06/01/07***D3353-7 FRONT PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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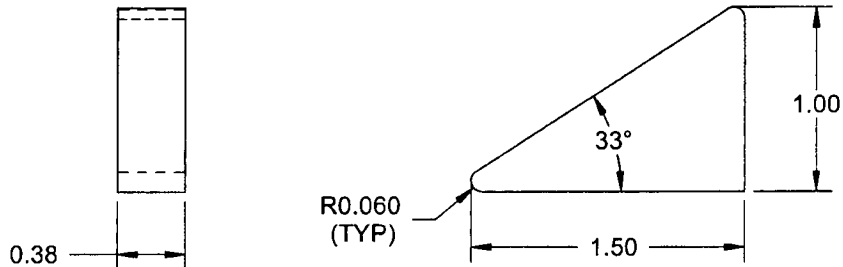
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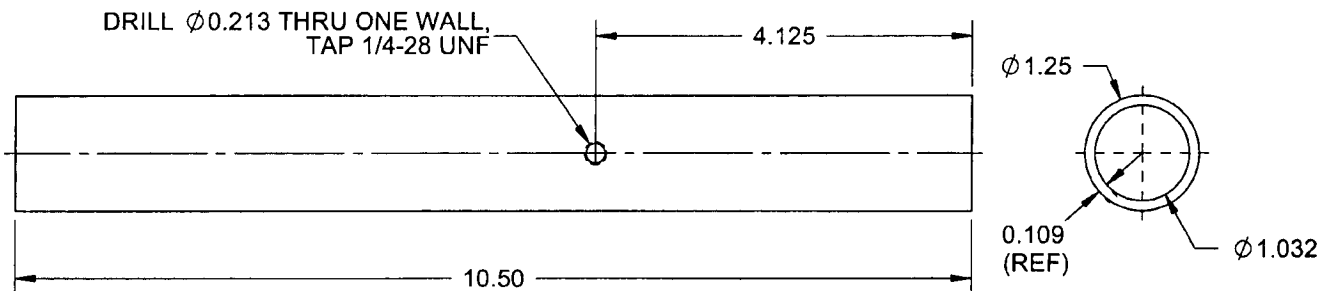
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:1

**RELEASED**  
3/3/09

[Signature]

**D3353-9 STOP PLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR  
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK  
MILD STEEL BAR (REF. DART SPEC. M1010-B)

**D3353-13 TUBING****NOTES:**

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,  
Ø 1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING  
(REF. DART SPEC. M1020TR1.250W.109)

**NOTES:**

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

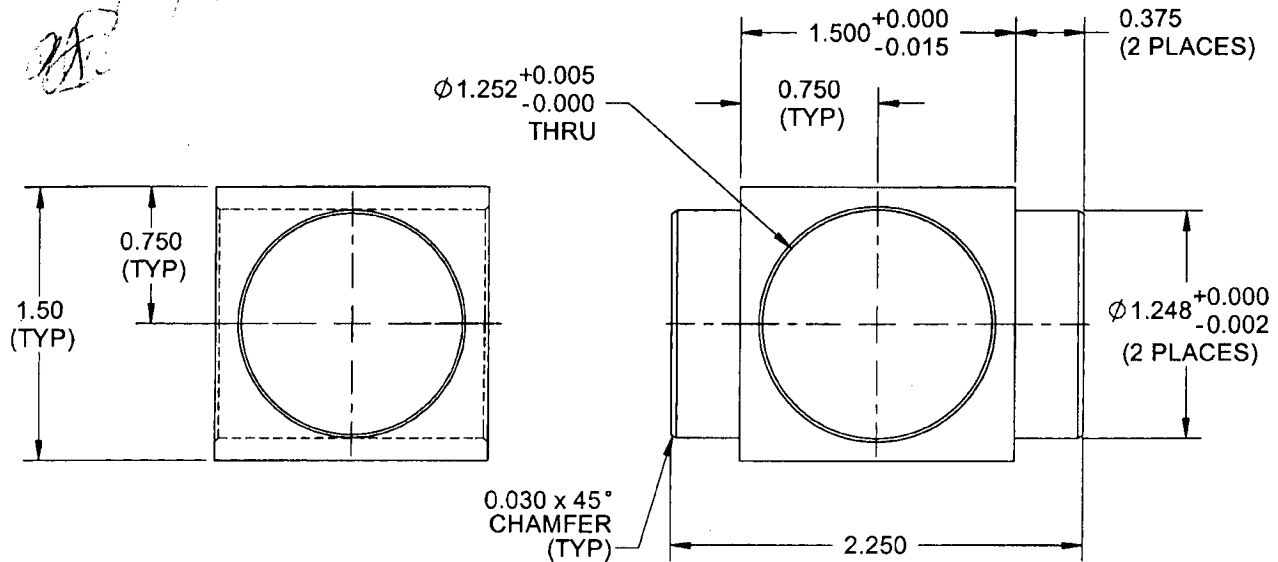
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:1

**RELEASED**  
**04/30/2014****D3353-11 UNIVERSAL JOINT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

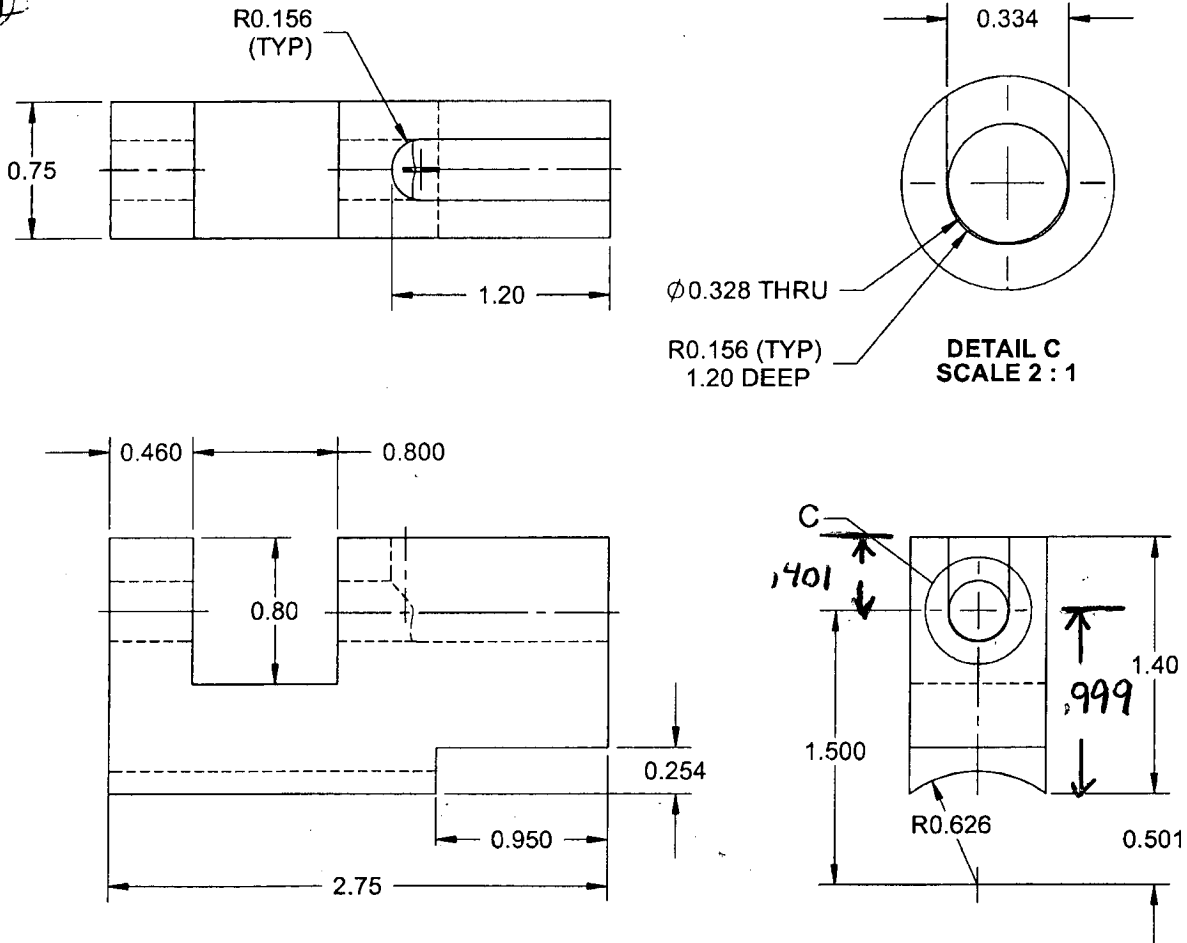
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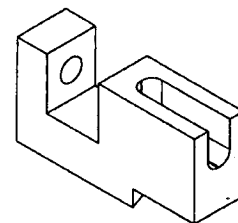
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:1

**RELEASED**  
*035/02/09***D3353-15 LOCK BRACKET****NOTES:**


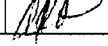
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

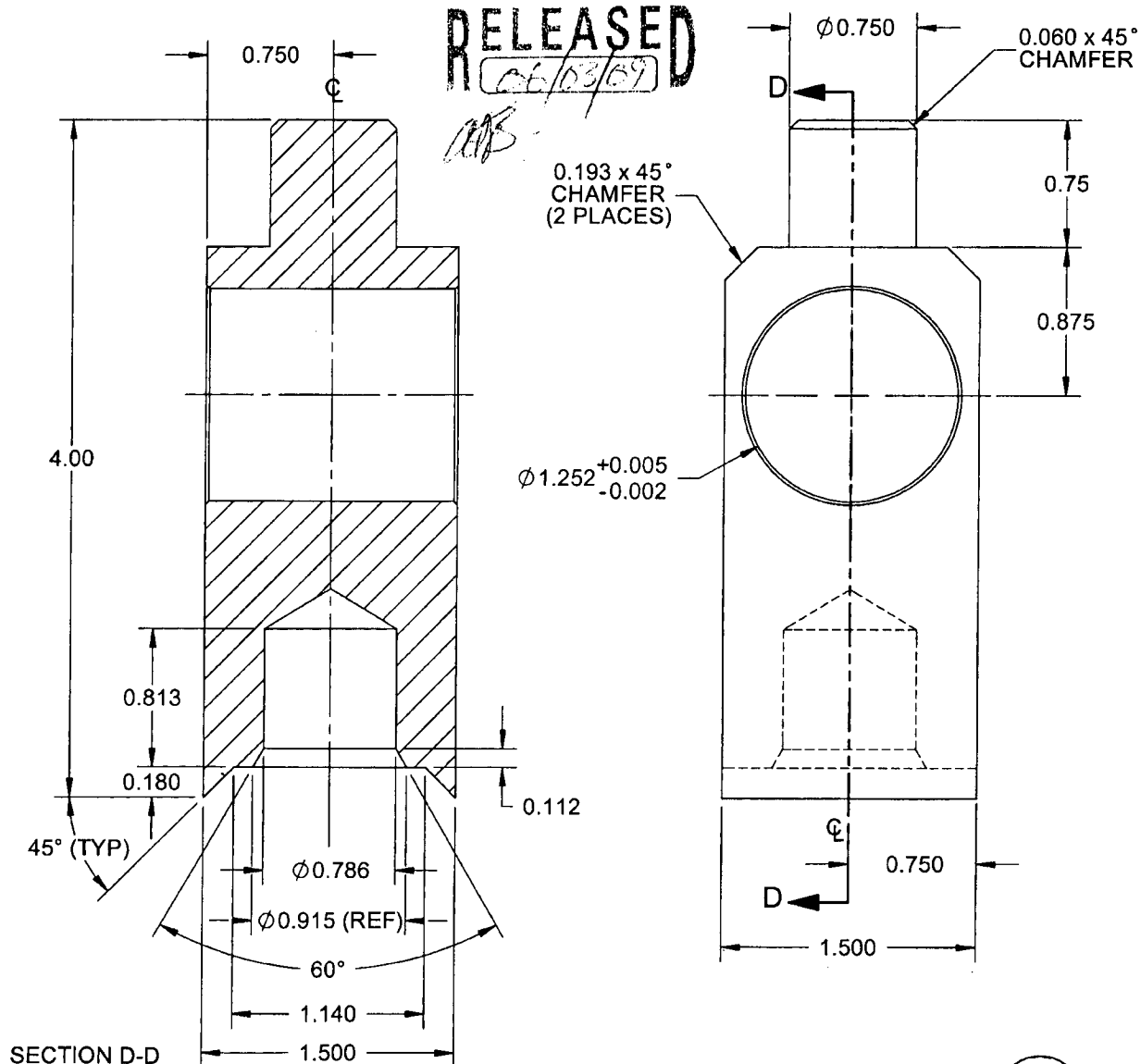
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SCALE 1:2**

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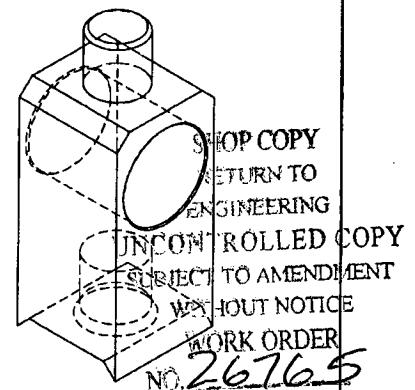
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DATE <b>04.12.14</b>		TITLE <b>LUG WELDMENT</b>	SCALE 1:1



**D3353-17 SUPPORT**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR  
CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD  
STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)  
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020



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Date: Wednesday, 5/24/2006 12:37:45 PM  
User: Chantal Lavoie

**INVENTORY ITEMS PICKED  
FOR SLIP NUMBER 2495**

**Project No.** : N/A  
**Customer** : Dart Helicopters Services  
**Part Number** : D335315  
**Job Number** : 26765

**Drawing Number** : D3353 REV.A  
**Drawing Name** : LUG WELDMENT  
**Due Date** : / /  
**Qty** : 8  
**Slip #** : 2495

		Location	Store	Picking	Lot No.	Serial No.	Req'd	Taken
1.0	M1010B0750X0200							
	1010-1025 BAR							
	Available	20.00	MAIN		17270		2.02	2.0160 f